


DART AEROSPACE LTD	Work Order:	22748
Description: Door Assembly	Part Number:	D3296-041
Dwg: D3296 Rev. A	Qty:	9
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	AF	05.03.17	5
2	MV	Cut blanks: 17.100" x 5.150" Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-1 Batch: M14646 M16807	EP	05/04/01	10
3	MV	Cut blanks: 17.100" x 5.150" Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-3 Batch: M15580 M16807	EP	05/04/01	10
4	MV	Machine as per Folio FA443 and Dwg D3296 Stack of 10 Identify as D3296-1	EP	05/04/05	10 (Pto)
5	QC2	Inspect parts as they come off the CNC machine	EP	05/04/05	10
6	QC8	Second check	EP	05.04.05	10
7	MV	Machine as per Folio FA443 and Dwg D3296 Stack of 10 Identify as D3296-3	EP	05/04/05	10 (Pto)
8	QC2	Inspect parts as they come off the CNC machine	EP	05/04/05	10
9	QC8	Second check	EP	05.04.05	10
10	GA	Deburr D3296-1/-3	SB	05/04/11	10
11	FP	Chemical Conversion Coat as per QSI 005 4.1	J	05.04.20	10
12	QC3	Inspect Chemical Conversion Coat	M	05/04/20	10
13	GA	Assemble hinges as per Dwg D3296 Pick: Qty Part Number Description Batch 1 D3161-7 Hinge 621427(x3) 622380(x7) 1 D3161-9 Hinge 322750 25 MS20470AD4-4 Rivet M15825	J	05.04.25	9 (Pto)
14	FP	Powder Coat Black Sandtex (Ref. 4.3.5.7) as per QSI 005 4.3	FF	05/5/12	10
15	QC3	Inspect Powder Coat	ML	05 05 12	10

RELEASED
7/11/28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-04-25	13	Give A dimension for Hole location to to center the holes on top hinge. on Dwg 3296	J	N/A 05-05-20		 05-04-25	2 05-04-25	

NCR: 22748		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/04/05	# 4	D3296-1 one stack of D3296-1 (10) scrap. Parts moved in Dowels.	<i>[Signature]</i> 05-04-05	Destroy & replace	<i>[Signature]</i> 05/04/05	<i>[Signature]</i> 05-04-05	<i>[Signature]</i> 05-04-05	<i>[Signature]</i> 05-04-05
05/04/05	# 7	one stack (10) of D3296-3 scrap. Parts moved in Dowels.	<i>[Signature]</i> 05-04-05	Destroy & replace	<i>[Signature]</i> 05/04/05	<i>[Signature]</i> 05-04-05	<i>[Signature]</i> 05-04-05	<i>[Signature]</i> 05-04-05
05-05-02	13	1x D3296-1 missing in action - checked Acid Alodine tanks All of finishing: G.A.	<i>[Signature]</i> 05-05-02	- scraped - stock D3296-3	<i>[Signature]</i> 05-05-02	<i>[Signature]</i> 05-05-02	<i>[Signature]</i> 05-05-02	<i>[Signature]</i> 05-05-02

Part No: D3296-041 PAR #: _____ Fault Category: rod/machined parts NCR:

Yes No DQA: 19

Date: 05/06/30

NOTE: Date & initial all entries

QA: N/C Closed: 42

Date: 05.06.30

DART AEROSPACE LTD	Work Order:	22748
Description: Door Assembly	Part Number:	D3296-041
Dwg: D3296 Rev. A	Qty:	59
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																																												
16	GA	<div>Fabricate & assemble as per Dwg D3296.</div> <div>Pick:</div> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D2137</td><td>Decal</td><td>B21425</td></tr><tr><td>1</td><td>D2419</td><td>Handle</td><td>B21425 B20697</td></tr><tr><td>1</td><td>D2462-0040</td><td>Seal</td><td>B19351</td></tr><tr><td>1</td><td>D2462-0053</td><td>Seal</td><td>B19351</td></tr><tr><td>1</td><td>D2462-0245</td><td>Seal</td><td>B19351</td></tr><tr><td>1</td><td>D2728-1</td><td>Decal</td><td>B17991</td></tr><tr><td>1</td><td>D3296-1</td><td>Door Panel</td><td>B22748</td></tr><tr><td>1</td><td>D3296-3</td><td>Door Panel</td><td>B22748</td></tr><tr><td>1</td><td>AN960JD6</td><td>Washer</td><td>M4970</td></tr><tr><td>1</td><td>MS20470AD4-6</td><td>Rivet</td><td>M14206</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D2137	Decal	B21425	1	D2419	Handle	B21425 B20697	1	D2462-0040	Seal	B19351	1	D2462-0053	Seal	B19351	1	D2462-0245	Seal	B19351	1	D2728-1	Decal	B17991	1	D3296-1	Door Panel	B22748	1	D3296-3	Door Panel	B22748	1	AN960JD6	Washer	M4970	1	MS20470AD4-6	Rivet	M14206	ml	05-05-24	9
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1	MS20470AD4-6	Rivet	M14206																																														
17	QC5	Inspect work to Step 20	J	05-06-07	5																																												
18	ST	Identify and Stock	CY	05/06/15	9																																												
19	AC	Cost / part: 99.38	SUC	05-06-17	9																																												
20	DC	Close W/O 96.90 Inspect Level 21	HA	05.06.30	9																																												

Rev	Date	Change	Revised By	Approved
A	04.08.24	New issue	KJ/JLM	
B	04.11.26	Revised Steps 13-17	KJ/JLM	

RELEASED
 04/11/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
						<i>W</i>	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/30	16	Half of 3 labels don't stick	<i>[Signature]</i> <i>verification</i>	Pull and Re-sand the corner. The labels are not still good, dirt on backs of labels, take new ones. Replace all of them (9)	<i>[Signature]</i> 05/05/30	<i>[Signature]</i> 05-06-20	<i>[Signature]</i> <i>undergill</i>	<i>2</i> 05-06-06

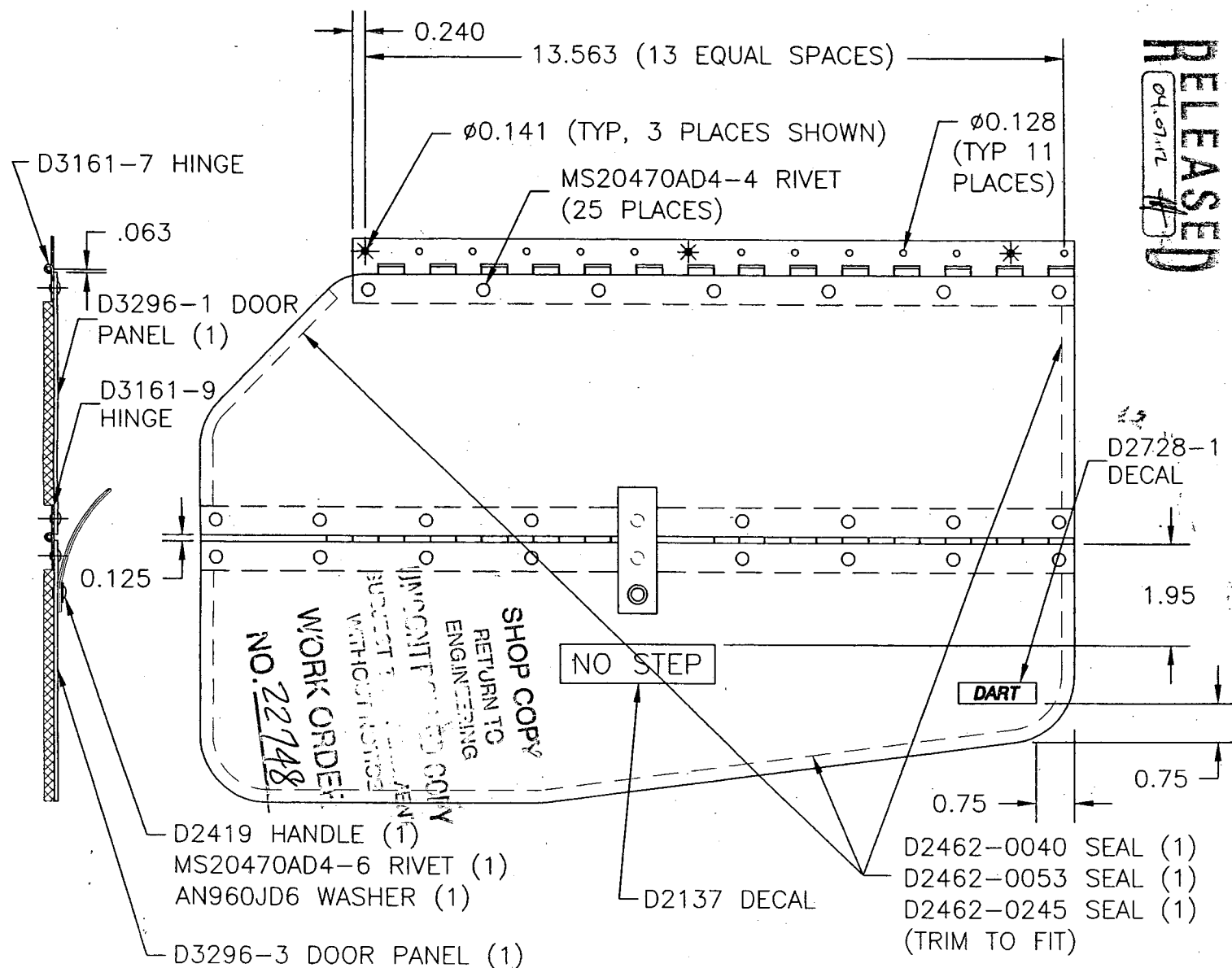
Part No: D3296-041 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/06/30

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



RELEASED
04.07.12

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO. D3296
DATE	04.06.28	TITLE	DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	NEW ISSUE		SCALE 1:3

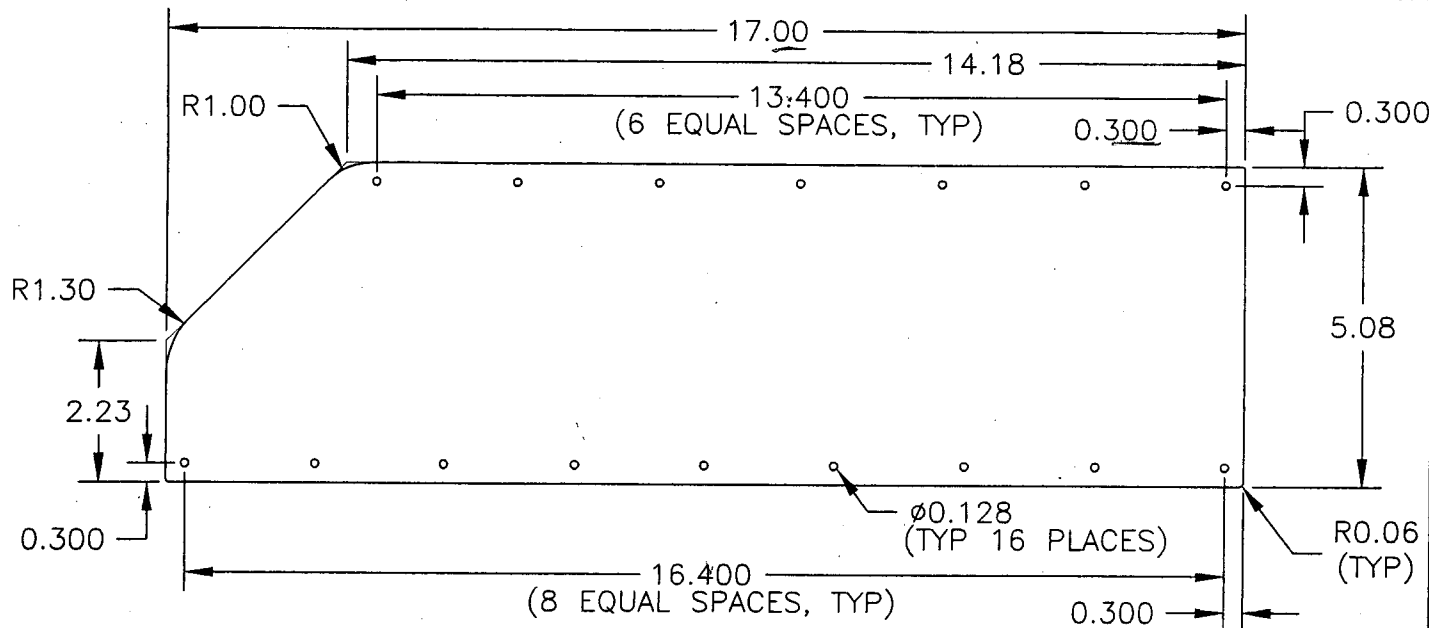


D3296-041 DOOR ASSEMBLY

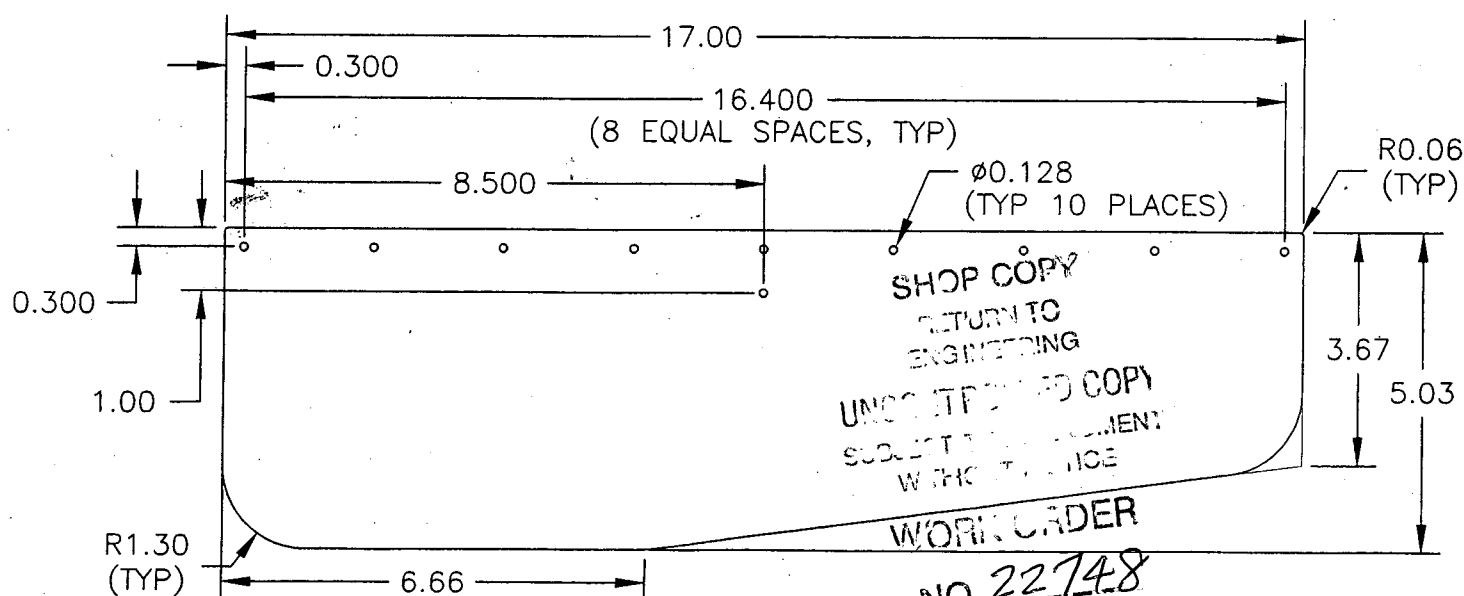
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 16, 2005
02:16 pm

Work Order No : 0022748
Project Name : D3296-041
Project For : WK514
Work Order Type : Main
Main WO Number :
House Part Number : D3296-041
Description : Door Assembly
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 03-16-05
Est Finish Date : 04-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00